

Work Order ID 158745

Thursday, March 30, 2017 3:55:53 PM

158745

Page 1

Item ID: D3574-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Cabin Floor Protector
Start Date: 3/31/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 4/4/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SCHEDULED/C

Approvals: Process Plan: DAS 21 9-89 Date: MAR 31 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3574	Rev B

100

0.00

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D3574

Dwg Rev: BProg Rev: B

2- Deburr

0.33

DAS
46
9-89117/04/01

110

0.00

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.01

DAS
46
9-89117/04/01

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

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Page 3

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Reference: SCHEDULED/C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location <u>OK</u>	0.00							
150									
Packaging	Memo	0.01				DAS 6 9-89		APR 03 2017	
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.10							
Quality Control									

17/4/4

DAS
21
9-89

APR 03 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Picklist Print

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Page 1

Work Order ID: 158745

158745

Parent Item: D3574-1

D3574-1

Parent Item Name: Cabin Floor Protector

Start Date: 3/31/2017

Required Date: 4/4/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev :A New Issue 07-01-22 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	2,313.091	21.55	25.35294		DAS 46 9-89	
MI FXS 125-F60029-04									**				
GE PLASTICS LEXAN SHEET (DARK GREY)													

Location

Loc Qty

Loc Code

MAT018

2313.091

m136228

2313.091

22.22

1764/61

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval					

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

DART AEROSPACE LTD		Work Order: 158745
Description: Cabin Floor Protector		Part Number: D3574-1
Inspection Dwg: D3574	Rev: B	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.003	✓		0.001	
7.37	+/-0.030	7.37	✓		Tape	
10.75	+/-0.030	10.75	✓			
11.00	+/-0.030	11.00	✓			
15.25	+/-0.030	15.25	✓			
25.87	+/-0.030	25.87	✓			
39.75	+/-0.030	39.75	✓			
44.75	+/-0.030	44.75	✓			
49.11	+/-0.030	49.11	✓			
51.11	+/-0.030	51.11	✓			
53.51	+/-0.030	53.51	✓			
63.50	+/-0.030	63.50	✓			
65.25	+/-0.030	65.25	✓			
10.75	+/-0.030	10.75	✓			
11.06	+/-0.030	11.06	✓			
14.75	+/-0.030	14.75	✓			
25.50	+/-0.030	25.50	✓			
25.75	+/-0.030	25.75	✓			
26.00	+/-0.030	26.00	✓			
32.87	+/-0.030	32.87	✓			
38.81	+/-0.030	38.81	✓			
44.75	+/-0.030	44.75	✓			
45.00	+/-0.030	45.00	✓			
48.25	+/-0.030	48.25	✓			
58.38	+/-0.030	58.38	✓			
61.25	+/-0.030	61.25	✓			
64.13	+/-0.030	64.13	✓			
64.63	+/-0.030	64.63	✓			
66.50	+/-0.030	66.50	✓			
7.50	+/-0.030	7.50	✓			
9.50	+/-0.030	9.50	✓			
10.38	+/-0.030	10.38	✓			
10.88	+/-0.030	10.88	✓			
14.50	+/-0.030	14.50	✓			

DART AEROSPACE LTD		Work Order: 158745
Description: Cabin Floor Protector		Part Number: D3574-1
Inspection Dwg: D3574 Rev: B		Page 2 of 2

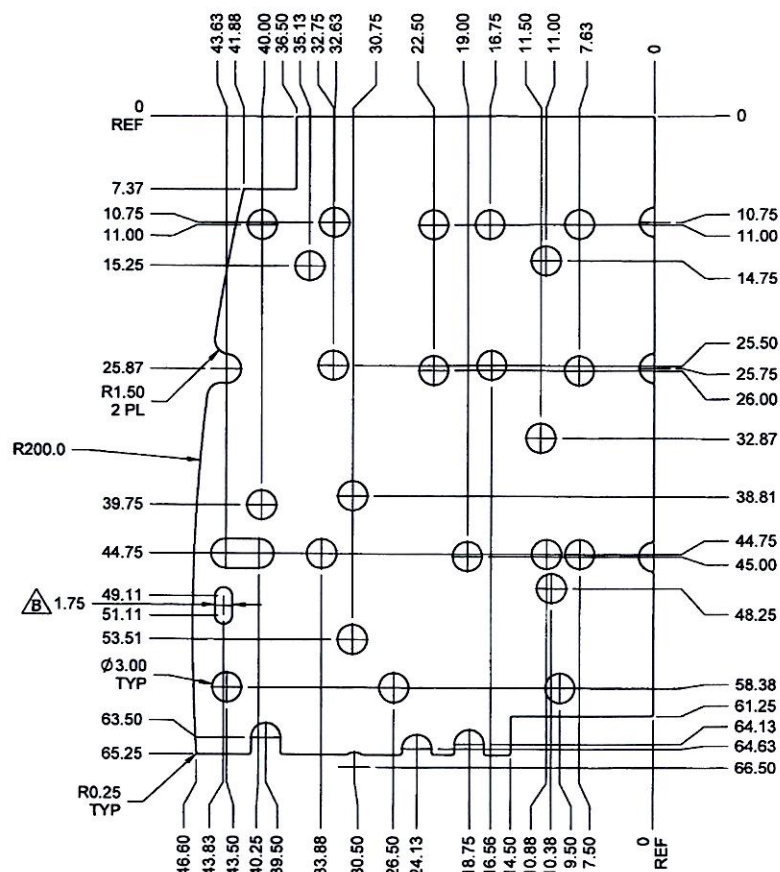
FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.56	+/-0.030	16.56	✓			
18.75	+/-0.030	18.75	✓			
24.13	+/-0.030	24.13	✓			
26.50	+/-0.030	26.50	✓			
30.50	+/-0.030	30.50	✓			
33.88	+/-0.030	33.88	✓			
39.50	+/-0.030	39.50	✓			
40.25	+/-0.030	40.25	✓			
43.50	+/-0.030	43.50	✓			
43.83	+/-0.030	43.83	✓			
46.60	+/-0.030	46.60	✓			
7.63	+/-0.030	7.63	✓			
11.00	+/-0.030	11.00	✓			
11.50	+/-0.030	11.50	✓			
16.75	+/-0.030	16.75	✓			
19.00	+/-0.030	19.00	✓			
22.50	+/-0.030	22.50	✓			
30.75	+/-0.030	30.75	✓			
32.63	+/-0.030	32.63	✓			
32.75	+/-0.030	32.75	✓			
35.13	+/-0.030	35.13	✓			
36.50	+/-0.030	36.50	✓			
40.00	+/-0.030	40.00	✓			
41.88	+/-0.030	41.88	✓			
43.63	+/-0.030	43.63	✓			
0.125	DAS 46 9-89 +/-0.010	0.125	✓			

Measured by: DAS 46 9-89	Audited by: DAS 38 9-89	Prototype Approval:	N/A
Date: 17/04/01	Date: APR 04 2017	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	
B	08.07.31	47.75 dimension removed	KJ/DD	
C	09.05.15	Dimensions updated per Dwg Rev B	KJ	



D3574-1 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-1" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.30 lbs
- 8) CHECK PER TEMPLATE DT8961

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 158745 MEX
17-03-31

RELEASED
01/04/07

B	ADD CUT-OUT TO -1/5 FOR WEIGHT AND BALANCE DATA PLATE ZN B7-1, B8-5; -2 NOW SHOWN ON SHEET 2	09.03.25
A	NEW ISSUE	CB 07.06.08
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.03.25	
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3574 REV. B TITLE CABIN FLOOR PROTECTOR SCALE NTS SHEET 1 OF 6 COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		